

Product Data Sheet

PHOEPOX® 4403

1/2

December 2019



Phoepox® 4403

is a fusion bonded epoxy powder that is designed for the internal corrosion protection of line pipes and fittings from seawater, saline water and industrial water. Phoepox® 4403 can be either applied together with a phenolic primer or as a standalone coating. Phoepox® 4403 passes BS 6920 requirements.

			Typical Value	Test Method / Device
POWDER PROPERTIES	GEL TIME	at 200°C	60-200 sec	ISO 8130-6
	THERMAL PROPERTY	Tg1	60 ± 5°C	ISO 21809-2
		Tg2	101 ± 5°C	
		ΔH	30-70 J/g	
	DENSITY		1.5 ± 0.1 g/cm ³	Gas Pycnometer
	PARTICLE SIZE		99.8% < 160 μm	Laser Scattering
	MOISTURE CONTENT		≤ 0.5 %	CSA Z245.20-06
COLOR		Grey		
PHYSICAL TESTS	CATHODIC DISBONDING *	1-3 mm at -3.5 VDC, 65°C, 24 hours 2-5 mm at -1.5 VDC, 20°C, 28 days		CSA Z245.20-06
	HOT WATER SOAK	Rating 1 at 75°C, 24 hours		CSA Z245.20-06
	FLEXIBILITY	Pass, at 3°, -30°C		CSA Z245.20-06
	SALT SPRAY TEST	No blistering at 50°C, 5 months		ASTM B117
	IMPACT	≥ 5J		CSA Z245.20-06
	ABRASION (TABER)	≤ 50 mg		ASTM D4060, at CS 17 wheel, 1000 cycles



◀ corrosion protection that stays.

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2/2

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STORAGE STABILITY 12 months from production date in $\leq 23^{\circ}\text{C}$ and $\leq 65\%$ relative humidity. Cooler temperatures and lower humidity are recommended.

* The performance will be affected by surface preparation and curing condition.

APPLICATION DATA

SUBSTRATE	Mild steel
SURFACE PREPARATION	Surface must be free from contamination and blasted as defined by Swedish Sa 2½
SURFACE ROUGHNESS	45-100 μm
RECOMMENDED FILM THICKNESS	150-500 μm
APPLICATION TEMPERATURE	190-240°C
TIME TO QUENCH	220°C, 12 min



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